

Work Order ID 136060

Thursday, August 27, 2015 2:29:12 PM

136060

Page 1

Item ID: D3580-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Joggle Bracket

Stop

NS2

Start Date: 8/27/2015 Start Qty: 50.00

50

Cust Item ID:

Required Date: 8/27/2015 Req'd Qty: 50.00

50

Customer:

Reference:

Approvals:

Process Plan: ML3

Date: AUG 27 2015

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3580	C

100

FLOW WATER JET

0.00

100

Waterjet

Memo

0.03

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: C

Prog Rev: C

2-Deburr if necessary

(50)

08/15/09/04

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.02

Quality Control

(50)

08/15/09/04

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.02

Quality Control

(50)

DA:

38

9-89

SEP 09 2015

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Item ID: D3580-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Joggle Bracket

Stop

NS2

Start Date: 8/27/2015 Start Qty: 50.00

50

Cust Item ID:

Required Date: 8/27/2015 Req'd Qty: 50.00

50

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.08

Quality Control

MW

SEP 14 2015

20150814
SA

Picklist Print

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Page 1

Work Order ID: 136060

136060

Parent Item: D3580-1

D3580-1

Parent Item Name: Joggle Bracket

Start Date: 8/27/2015

Required Date: 8/27/2015

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP Rev :A New Issue 07.06.25 EC
IPP Rev:B Removed Powder Coat 07-07-11 JLM

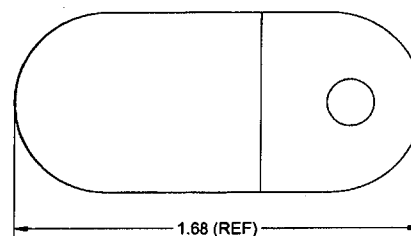
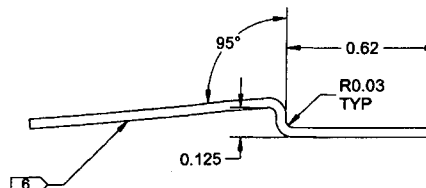
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S18GA		Purchased		No		100	sf	238.1776	0.009	0.473684			

M304S18GA

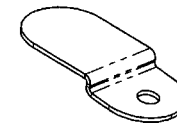
304/316 .050 Sheet

08/15/09/08

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT020	151.1276	
M128254	4.1887	
M128435	25	
M128864	31.5964	
M129530	34.3667	
M130923	28.0424	
M131384	20.4334	
M13279	7.5	
MAT20	87.05	
M131700	87.05	



D3580-1 JOGGLE BRACKET



UNCLAS
S

W 136060 MJS
15-08-27

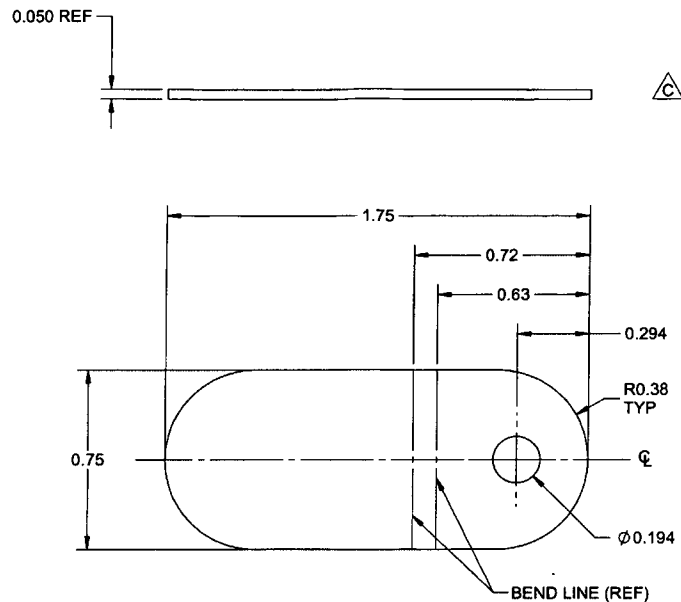
RELEASED
2014-07-02

NOTES:

- 1) MATERIAL: MADE FROM D3580-1F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1 ON THE UNDERSIDE OF THE PART AS INDICATED
- 7) WEIGHT: 0.01 lbs

C	UPDATED DWG FORMAT, ADDED D3580-3 (ZN B5-3) AND D3580-5 (ZN B5-4). ADDED SIDE VIEW TO D3580-1F (ZN D5-2)	AK	14.02.12
B	REMOVE POWDER COAT	CB	07.07.09
A	NEW ISSUE	CB	07.05.15
REV.	DESCRIPTION	BY	DATE
DESIGN	AK	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AK		
CHECKED	VS	DRAWING NO.	REV. C
MFG. APPR.	JLM	D3580	SHEET 1 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	JOGGLE BRACKET	NTS
DATE	14.02.12	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

APPROVED



D3580-1F FLAT PATTERN

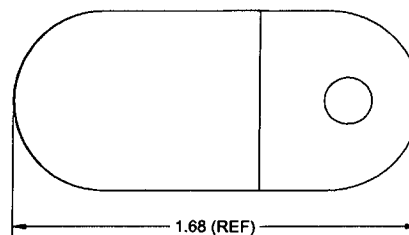
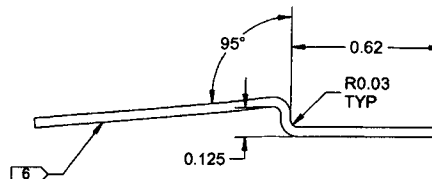
RELEASED
2014-07-02
WHP

NOTES:

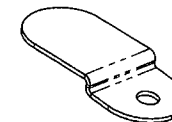
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 18 GAUGE (0.050 THICK)
PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240
(REF DART SPEC M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

APPROVED

DESIGN	AK	DART AEROSPACE LTD	
DRAWN	AK	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VS	DRAWING NO.	REV. C
MFG. APPR.	JLM	D3580	SHEET 2 OF 4
APPROVED	HS	TITLE	SCALE
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 **D3580-3 JOGGLE BRACKET**



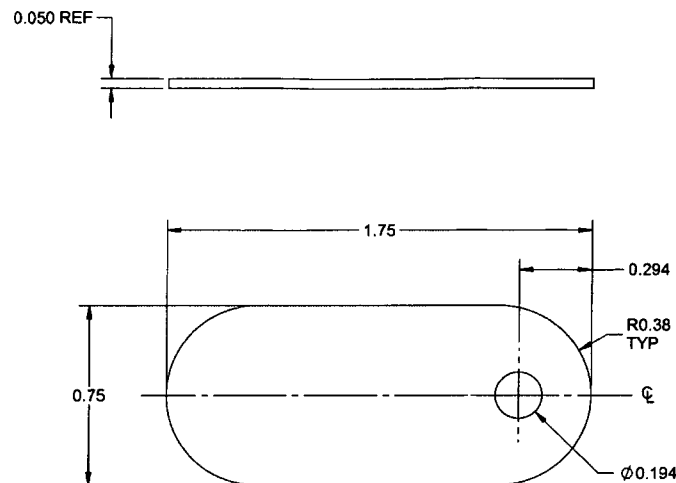
NOTES:

- 1) MATERIAL: MADE FROM D3580-1F
- 2) FINISH: POWDER COAT "BLACK" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1 ON THE UNDERSIDE OF THE PART AS INDICATED
- 7) WEIGHT: 0.01 lbs

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DESIGN	AK	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AK		
CHECKED	VS	DRAWING NO.	REV. C
MFG. APPR.	JLM	D3580	SHEET 3 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	JOGGLE BRACKET	NTS
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RELEASED
2014-07-02



D3580-5 BRACKET

RELEASED
2014-07-02

- NOTES:**
- 1) MATERIAL: MADE FROM D3580-1F
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 - 7) WEIGHT: 0.01 lbs

APPROVED

DESIGN	AK	DART AEROSPACE LTD	
DRAWN	AK	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VS	DRAWING NO.	REV. C
MFG. APPR.	JLM	D3580	SHEET 4 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	JOGGLE BRACKET	NTS
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